

Work-Order ID 131989

Tuesday, April 21, 2015 1:59:20 PM

131989

Page 1

Item ID: D2938-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle RH Out, 206
Start Date: 4/20/15 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 4/20/15 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: MCS Date: 15-04-22 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2938	Rev C								

100

0.00

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

0.07

Program part number and batch number.1-Inspect part number and batch number are programmed correctly.2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per

4φJFC 2015-04-28

110

0.00

110

Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

0.00

Machine Keyway and inspect per attached dimension sheet

4φJFC 2015-01-28

120

0.00

120

QC

Quality Control

QC1- Inspection performed by CMM

Memo

0.00

4φJFC 2015-04-2821505106

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

131989

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 4/20/15 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 4/20/15 **Req'd Qty:** 4.00 ***A***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

B.A 15/05/03

L

C

DAS
08
9-89

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

4 $\emptyset$ Jm15-5-6

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:10 OVEN TEMPERATURE: 320
FINISH TIME: 10:40

H & B-5-12

DAS 34 0.90

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
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Description Work Order Deviation				Disposition				Completed By			
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Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : _____											

Tuesday, April 21, 2015 1:59:20 PM

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Page 3

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 4/20/15 **Start Qty:** 4.00

4

Customer:

Required Date: 4/20/15 **Req'd Qty:** 4.00

4

Reference:

Run Start *NR1*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

33
 33
 9-69
 MAY 12 2015

Identify as per dwg & Stock Location: *54 548*

0.00

170

Packaging

Memo

0.00

Packaging

4 DAS
27
9-23
MAY 14 2015

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.01

Quality Control

MUS MAY 15 2015

MCS MAY 14 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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OTHER :																																																																				

Picklist Print

Tuesday, April 21, 2015 1:59:20 PM

Page 1

Work Order ID: 131989

131989

Parent Item: D2938-2

D2938-2

Parent Item Name: Saddle RH Out, 206

Start Date: 4/20/15

Required Date: 4/20/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	23.0000	1	4			

D6101-003

Saddle Billet, 7075

Location

Loc Qty

Loc Code

MAT044

23

120394

1

128906

2

129920

10

130770

10

4

JFC 2015-04-24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER :					

DART AEROSPACE LTD	Work Order: 131989
Description: 206 Saddle, Outboard, Right side	Part Number: D2938-2
Inspection Dwg: D2938 Rev. C	Page 1 of 1

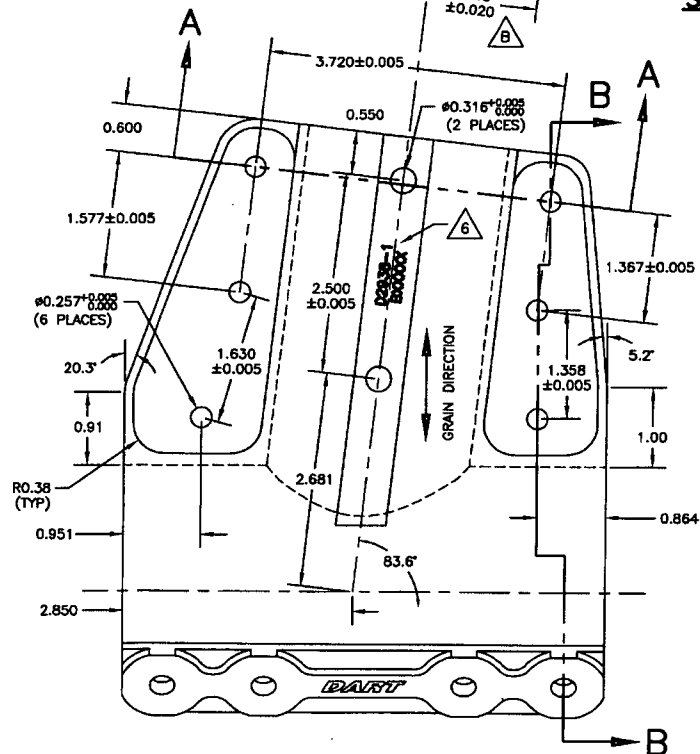
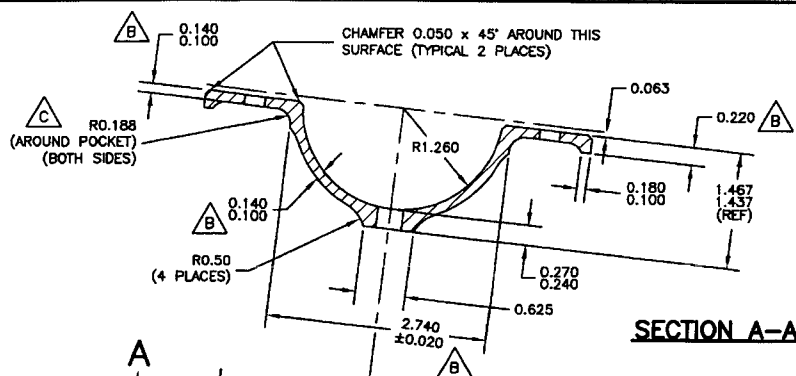
Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140	0.132	0.135	0.133	0.134	0.134		
B	0.100	0.140	0.135	0.135	0.134	0.134	0.134		
C	0.100	0.140	0.130	0.130	0.128	0.130	0.130		
D	0.210	0.230		0.226	0.225	0.226	0.225		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.240	0.239	0.239	0.239		
N	0.100	0.140		0.127	0.127	0.126	0.126		
O	0.540	0.560		0.548	0.547	0.548	0.548		
P	0.490	0.510		0.498	0.501	0.499	0.499		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270	0.253	0.250	0.252	0.253	0.253		
T	0.100	0.180		0.142	0.142	0.142	0.142		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		0.317	0.317	0.317	0.317		
X	1.250	1.270	1.263	1.263	1.2634	1.262	1.2618		
Y	1.565	1.585	1.576	1.576	1.576	1.5758	1.5728		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

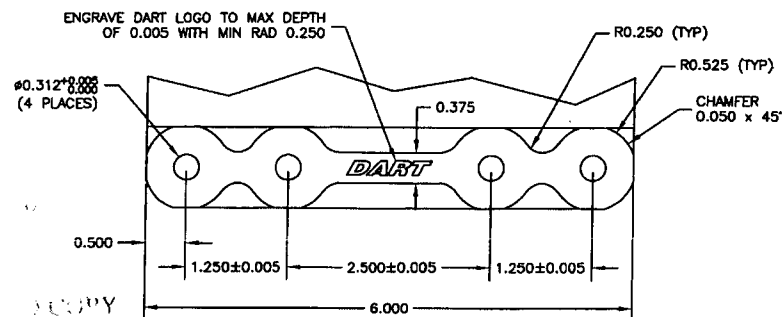
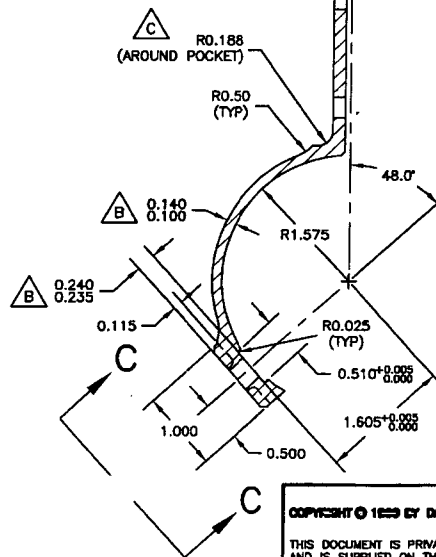
Measured by: JFC
Date: 2015-01-28

Audited by: H.E.	DAS
Date: 15/05/03	08
	9-89

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



SECTION B-B



D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE SADDLE OUTSIDE
DRAWING NO. D2938		REV. C SHEET 1 OF 1 SCALE 2:3

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DART AEROSPACE USA, INC.
BELLINGHAM, WA

DRAWING NO. D2938

TITLE SADDLE OUTSIDE

07.02.12



Part Number: D2938-2	Rev: C	- Page 1 -
Description: SADDLE OUTSIDE	Inspection Dwg: D2938	Work Order: 131989

Name	Nominal	Upper Tol Lower Tol	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	
A Formula calculation	0.120	0.020 -0.020	0.132	0.133	0.134	0.134	
B Formula calculation	0.120	0.020 -0.020	0.135	0.134	0.134	0.134	
C Formula calculation	0.120	0.020 -0.020	0.130	0.128	0.130	0.130	
D Distance YZ	0.2200	0.0100 -0.0100	0.2238	0.2222	0.2242	0.2234	
E Distance XY	1.2500	0.0050 -0.0050	1.2487	1.2499	1.2504	1.2501	
F Distance XY	1.2500	0.0050 -0.0050	1.2500	1.2503	1.2507	1.2495	
G Distance XY	2.5000	0.0050 -0.0050	2.4998	2.4992	2.4987	2.4998	
H Formula calculation	0.510	0.005 0.000	0.512	0.512	0.512	0.512	
I Distance XY	1.5770	0.0050 -0.0050	1.5773	1.5776	1.5778	1.5777	
J Distance XY	2.5000	0.0050 -0.0050	2.4999	2.4997	2.4982	2.5000	
K Diameter	0.2570	0.0050 -0.001	0.2576	0.2569	0.2566	0.2570	
L Diameter	0.3120	0.0050 -0.001	0.3120	0.3123	0.3110	0.3121	
M Formula calculation	0.235	0.005 0.000	0.240	0.239	0.239	0.239	
N Distance YZ	0.1200	0.0200 -0.0200	0.1265	0.1254	0.1260	0.1255	
O Distance XY	0.5500	0.0100 -0.0100	0.5484	0.5481	0.5489	0.5484	
P Distance XY	0.5000	0.0100 -0.0100	0.5008	0.4996	0.4980	0.4966	
Q Distance XY	3.7200	0.0050 -0.0050	3.7184	3.7187	3.7194	3.7182	
R Distance XY	2.7400	0.0200 -0.0200	2.7463	2.7468	2.7477	2.7469	

Measured by:
Mathieu Lamarche

Date:
2015-5-6

Audited by:

Date:



Part Number: D2938-2	Rev: C	- Page 2 -
Description: SADDLE OUTSIDE	Inspection Dwg: D2938	Work Order: 131989

Name	Nominal	Upper Tol Lower Tol	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	
S Formula calculation	0.255	0.015 -0.015	0.253	0.252	0.253	0.253	
T Formula calculation	0.140	0.020 -0.020	0.142	0.142	0.142	0.142	
U Distance XY	1.6300	0.0050 -0.0050	1.6293	1.6296	1.6300	1.6297	
V Distance XY	1.3670	0.0050 -0.0050	1.3674	1.3667	1.3676	1.3674	
W Diameter	0.3160	0.0050 -0.0010	0.3157	0.3146	0.3144	0.3133	
X Formula calculation	1.260	0.010 -0.010	1.263	1.263	1.262	1.262	
Y Formula calculation	1.575	0.010 -0.010	1.576	1.576	1.576	1.573	
Z Radius	0.1880	0.0100 -0.0100	0.1911	0.1927	0.1917	0.1972	

Measured by:
Mathieu Lamarche

Date:
2015-5-6

Audited by:

Date: